

Work Order ID 117597

April-28-14 11:13:36 AM

\*117597\*

Page 1

Item ID: D5061-3

Revision ID:

Item Name: Aft Wearplate

Start Date: 4/28/14

Start Qty: 10.00

Required Date: 5/12/14

Req'd Qty: 10.00

Reference:

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: MJS

Date: 1404-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D5061

A

110

0.00

\*110\*

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1- Cut as per Dwg  
Dwg Rev: A  
Prog Rev: A  
2-Deburr if necessary

10

0

Jm14-05-1

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

10

0

Jm14-05-1

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

10

14/5/11

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**\*117597\***

Page 2

Item ID: D5061-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Wearplate  
 Start Date: 4/28/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 5/12/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 <b>*140*</b> Brake NC Brake NC	Form as per dwg NC BRAKE  Memo Form joggle as per dwg.	0.00  0.00		DAS 30 9-89		18			14/05/05
150 <b>*150*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00  0.00				18			
160 <b>*160*</b> Large Fab Large Fab	Large Fab  Memo Weld hard surface as per QS1004 and Dwg D5061 2059 Hardcoat Rod <u>M129283</u>	0.00  0.00				8			14-06-23 MAL

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Item ID: D5061-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Wearplate  
 Start Date: 4/28/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 5/12/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									
183		0.00							
<b>*183*</b>									
HandFinish	Memo	0.00							
Hand Finishing	APPLY ROCKGARD AS PER DWG								
	A/R ROCKGARD BATCH: <u>129763</u>								

① 14-08-13 DAS  
9  
9-89

① 14-08-13 DAS  
9  
9-89

① ————— CH 14-08-13



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Item ID: D5061-3 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Aft Wearplate

Start Date: 4/28/14 Start Qty: 10.00 \*10\* Cust Item ID:

Required Date: 5/12/14 Req'd Qty: 10.00 \*10\* Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
186	QC3- Inspect Part Finish	0.00				9	8	20	14/08/14
*186*									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: EP.002	0.00				x9	0	41	14-08-19
*190*									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00				MLJ		14-08-19	
*200*									
QC	Memo	0.00							
Quality Control									

4-8-19

# Picklist Print

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Page 1

Work Order ID: 117597

\*117597\*

Parent Item: D5061-3

\*D5061-3\*

Parent Item Name: Aft Wearplate

Start Date: 4/28/14

Required Date: 5/12/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.02.13 NEW ISSUE DD VERF:JLM IPP  
REV:B 14.04.21 rev.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No				sf	628.7100		34			

\*M304S18GA\*

304/316 .050 Sheet

\*\*

Jm 14-05

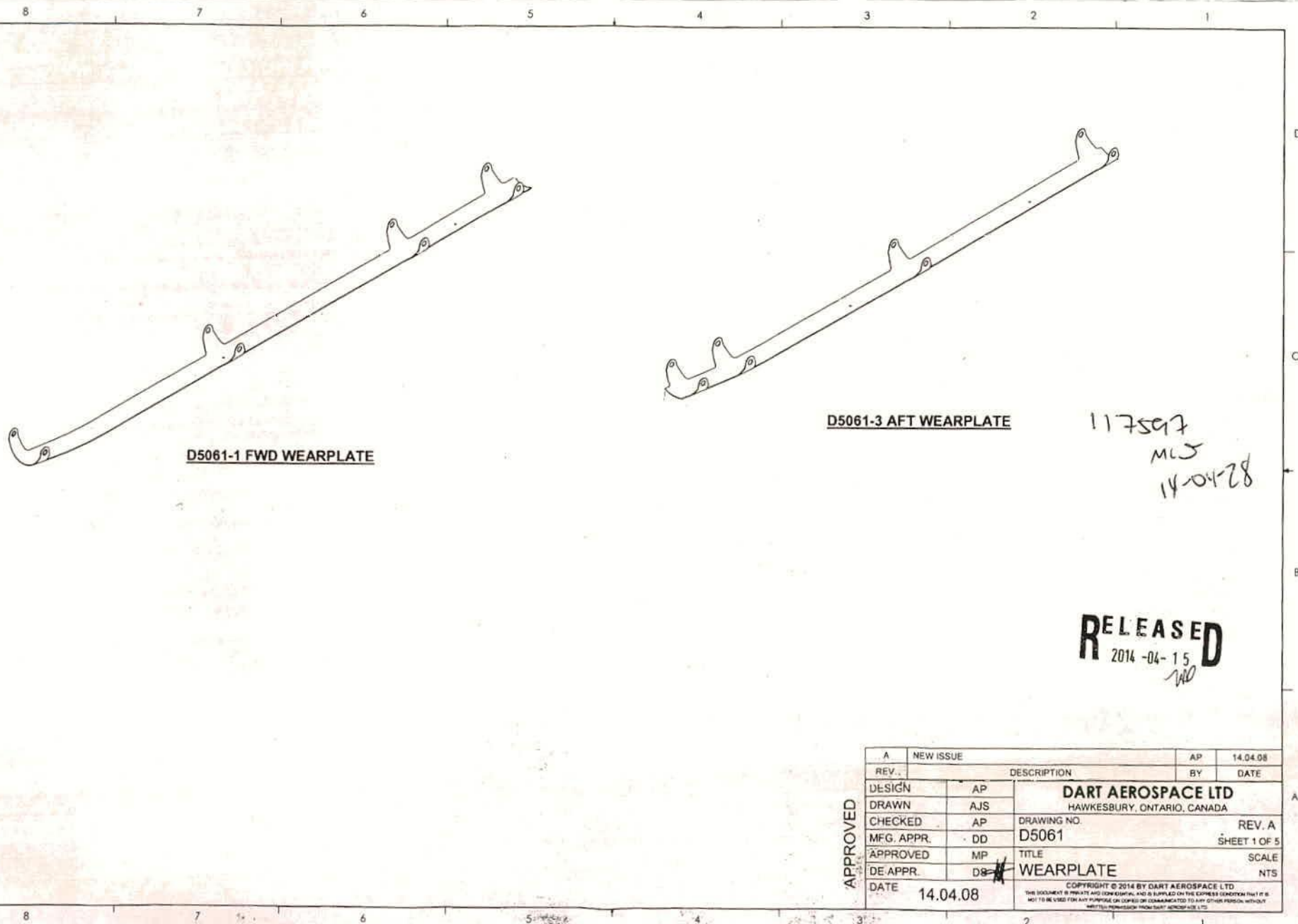
Location	Loc Qty	Loc Code
MAT019	616.71	
117188	3	
117766	5	
120604	5	
122325	3	
123155	3	
124572	38	
M126647	39.75	
M128254	108.71	
M128435	187.25	
M128864	224	
MAT020	12	
124029	2	
M126098	10	

128864

854  
2928



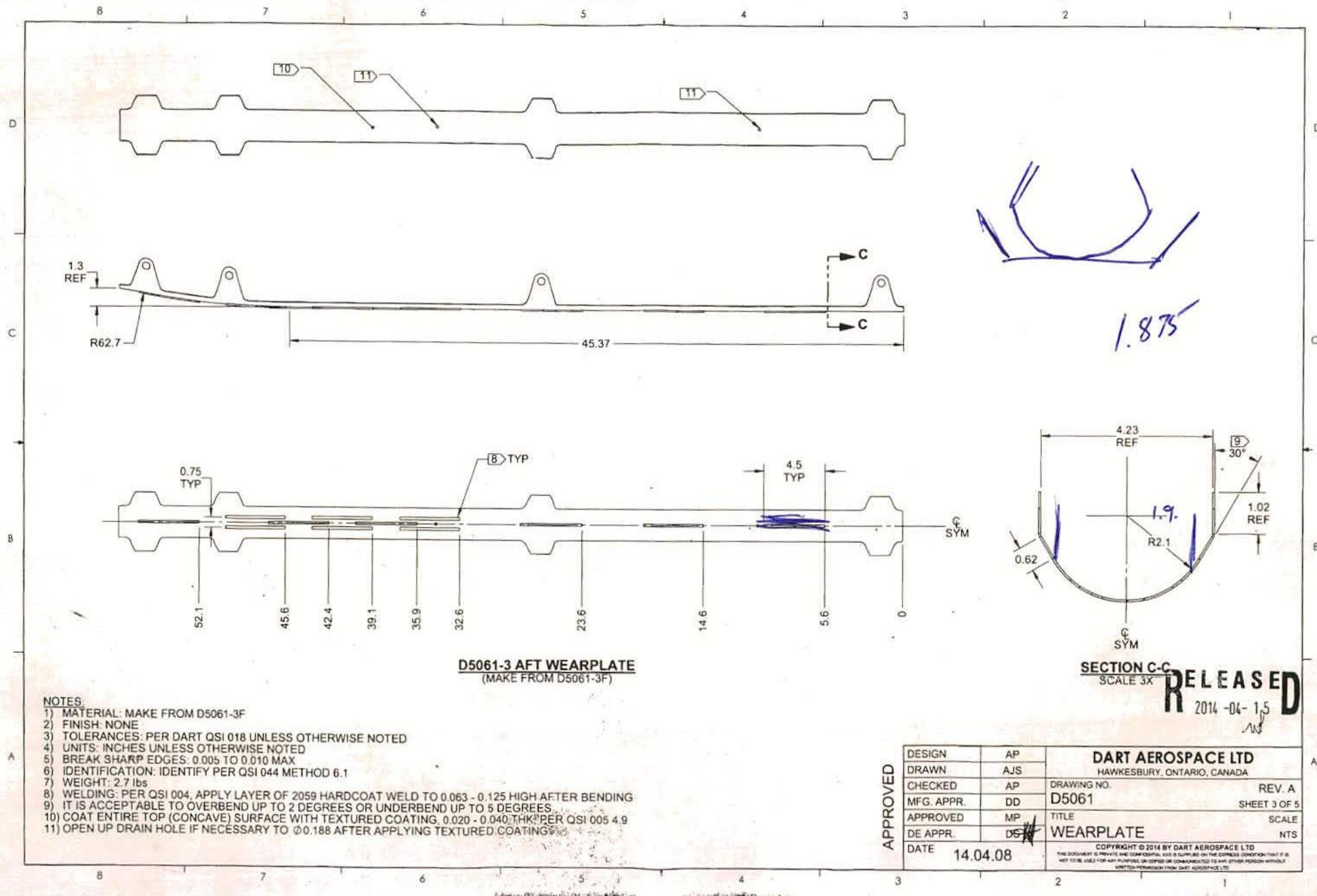




11757  
ML5  
14-04-28

**RELEASED**  
2014-04-15  
140

APPROVED	REV.	NEW ISSUE	AP	14.04.08
	DESIGN	AP	DESCRIPTION	
	DRAWN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5061	SHEET 1 OF 5
	APPROVED	MP	TITLE	SCALE
DE APPR.	D8	WEARPLATE	NTS	
DATE	14.04.08		<small>COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



**D5061-3 AFT WEARPLATE**  
(MAKE FROM D5061-3F)

**NOTES**

- 1) MATERIAL: MAKE FROM D5061-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 2.7 lbs
- 8) WELDING: PER QSI 004, APPLY LAYER OF 2059 HARDCOAT WELD TO 0.063 - 0.125 HIGH AFTER BENDING
- 9) IT IS ACCEPTABLE TO OVERBEND UP TO 2 DEGREES OR UNDERBEND UP TO 5 DEGREES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THK PER QSI 005 4.9
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO Ø0.188 AFTER APPLYING TEXTURED COATING

APPROVED

DESIGN	AP
DRAWN	AJS
CHECKED	AP
MFG. APPR.	DD
APPROVED	MP
DE APPR.	DS
DATE	14.04.08

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D5061</b>	REV. A
TITLE <b>WEARPLATE</b>	SCALE NTS
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**SECTION C-C**  
SCALE 3X

**RELEASED**  
2014-04-15